








Work Order ID 52297

Tuesday, September 22, 2009 1:57:42 PM

Page 1

Item ID: D3927-3	Accept		Setup	Start	
Revision ID: A				Stop	
Item Name: Guard					
Start Date: 9/23/2009	Start Qty: 5.00		Cust Item ID:		
Required Date: 10/9/2009	Req'd Qty: 5.00		Customer:		

Reference:

Approvals:	Process Plan: <u>B</u>	Date: <u>09-9-22</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3927	A								

100

0.00



Bandsaw

Memo

0.00

am 09/10/23

5+2

Jeaspa Bandsaw

Cut MAT 19.250" Long

110

0.00



HAAS 1

Memo

0.00

am 09/10/23

5 2

HAAS CNC vertical machine #1

HAAS

1-Mill as per folio FA & dwg D,
FOLIO REV: 2
DWG REV: 1

2-Deburr as required



W/O: 52297		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.11.17	110	BREAK QTY(4) SHARP CORNERS ON CHAMFERED SIDE 0.125" TO REMOVE KNIFE POINTS.	AMF	09/11/18	4	GP 09.11.17 per QSI 042	S 02/11/18

Part No: D3927-3 PAR #: 01-041 Fault Category: Eng-design NCR: Yes No DQA: 2 Date: 09-11-27
 Resolution: scrap Disposition: scrap QA: N/C Closed: 2 Date: 02-11-27

NCR: 52297		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/10/27	110.	3 part are affected By corner chip when Machined the angle 21° P.C. design	GP 09.11.17 per QSI 042	Replace 2 parts Batch # M112782 NO more material EDGES MACHINED FLAT. QTY(1) PART OK. SCRAP (2)	SE 09/10/27	H.A 09/11/18	GP 09.11.17 per QSI 042	S 02/11/18

NOTE: Date & initial all entries

Work Order ID 52297

Tuesday, September 22, 2009 1:57:42 PM

Page 2

Item ID: D3927-3

Accept

Revision ID: A

Item Name: Guard

Setup Start

Stop

Start Date: 9/23/2009 Start Qty: 5.00

Required Date: 10/9/2009 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

J.L. 09/11/16

5

2

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

J.A. 09/11/18

5

2

Quality Control

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

9/11/18 [Signature]

Packaging

Work Order ID 52297

Tuesday, September 22, 2009 1:57:42 PM

Page 3

Item ID: D3927-3

Accept

Revision ID: A

Item Name: Guard

Start Date: 9/23/2009 Start Qty: 5.00

Required Date: 10/9/2009 Req'd Qty: 5.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21 - Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/09

BH 09-11-09 E

Picklist Print

Tuesday, September 22, 2009 1:57:41 PM

Page 1

Work Order ID: 52297



Parent Item: D3927-3RevA



Parent Item Name: Guard

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MDELRJNB2.000X02.0 00		Purchased	No			100	f	1.0147	8.8421			



DELIN BAR

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1.0147

111828

1.0147

1112782

ent 09/10/24

8.8421

DART AEROSPACE LTD		Work Order: 52297
Description: Guard		Part Number: 03927-2
Inspection Dwg: 03927	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

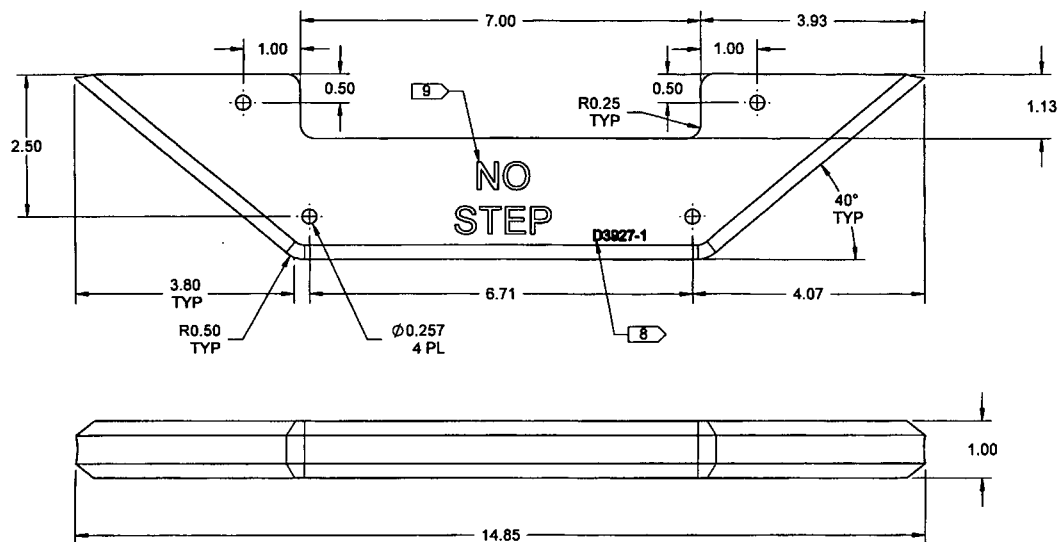
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.52	±.030	1.523	✓			
1.52	Ref	1.527	✓			
1.23	±.03	1.230	✓			
.98	"	.981	✓			
.50	"	.501	✓			
.0600	"	.596	✓			
.800	"	.794	✓			
.880	"	.895				
1.50	"	1.503	✓			
15.00	"	15.00	✓			
19.00	"	19.0	✓			
18.50	"	18.5	✓			
1.04	"	1.041	✓			
1.10	"	1.098	✓			
R.25	"	.25	✓			
R.45	"	R.44	✓			
R 1.58	"	1.58	✓			
.25x45° CH	"	.260x45°	✓			

Measured by: <i>[Signature]</i>
Date: 09/10/27

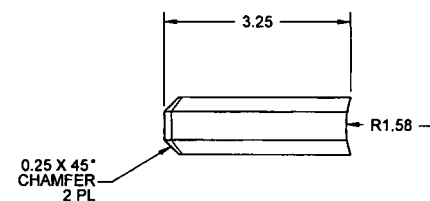
Audited by: M.A
Date: 09/11/18

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK ORDER
NO. 52297



D3927-1 GUARD

RELEASED
09/03/31

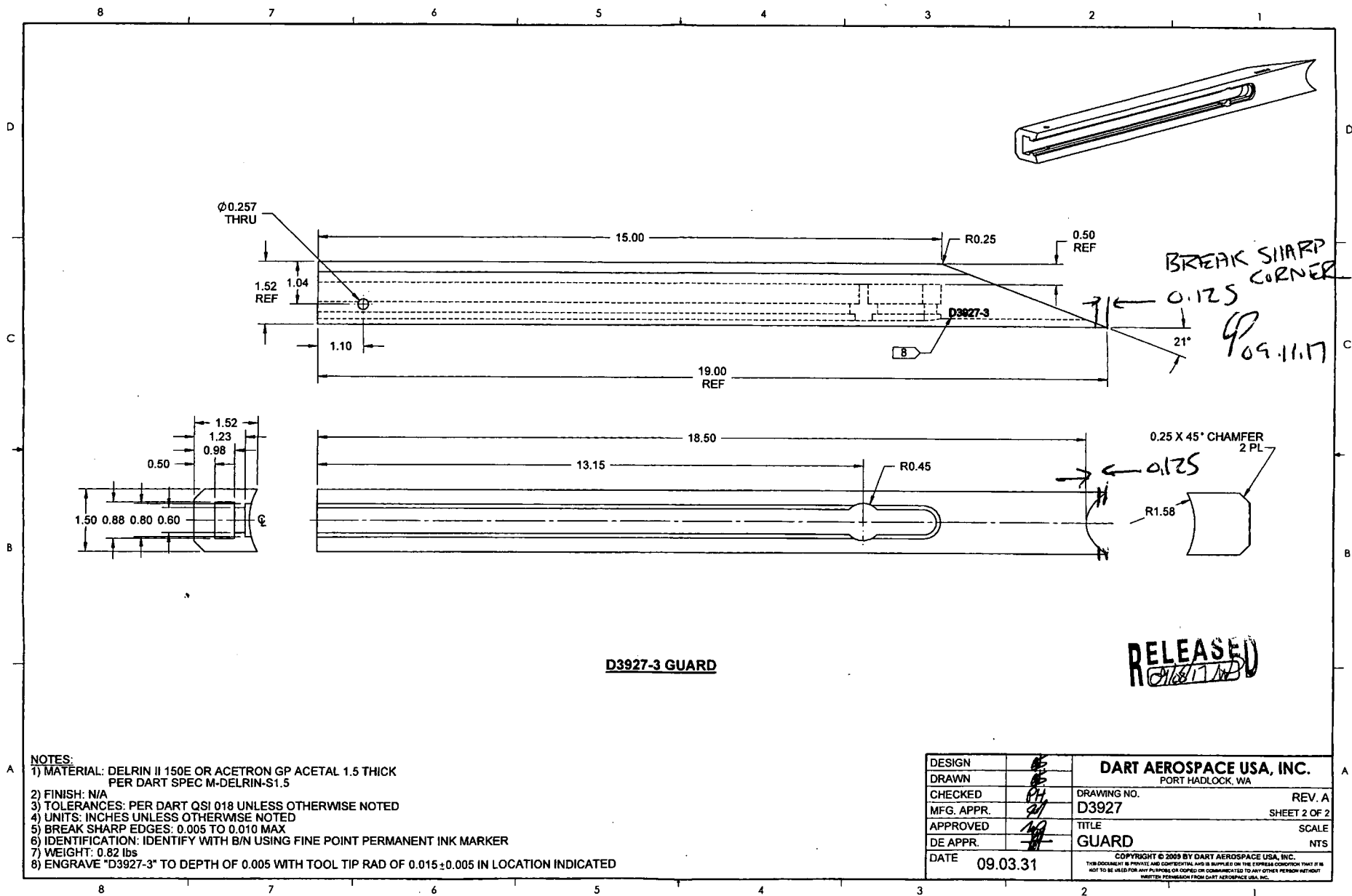
NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL 1.0 THICK
PER DART SPEC M-DELRIN-S1.0
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.90 lbs
- 8) ENGRAVE "D3927-1" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015±0.005 AT LOCATION INDICATED
- 9) ENGRAVE "NO STEP" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015±0.005 AT LOCATION INDICATED

A NEW ISSUE		BY	DATE
REV.	DESCRIPTION		
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.31		

DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. A
DRAWING NO. D3927		SHEET 1 OF 2
TITLE GUARD		SCALE NTS
COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO REUSE OR DISSEMINATION IS PERMITTED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

52297



D3927-3 GUARD

RELEASED
09/03/31

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3927	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GUARD	NTS
DATE	09.03.31	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	